

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006622**Date Inspected:** 03-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Liang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Blast Bay 1-

This QA Inspector performed a preliminary random visual inspection after the grit blast of the exterior components of assemblies of segment 2AW. Numerous Gouges in the Base metal where temporary welds were removed by ZPMC were found in various locations on exterior Deck Panel components. Gouges up to 5 mm in depth were found. Numerous arc strike areas were found during inspection and were marked for grinding. ZPMC personnel did not perform Magnetic Particle Inspection after grinding of these areas prior to grit blasting. ZPMC QC personnel were made aware of these locations. Below are photos of one of the gouge areas that were observed during this inspection. An incident report was issued for the above mentioned items of non conformance.

Bay 11-

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as West Tower Lift 3Skin D plate , WSD1-FDSA3-2 B/C (A side). The weld identification numbers are as follows, WSD1-FDSA3-2 B/C 35, 38 and 54.

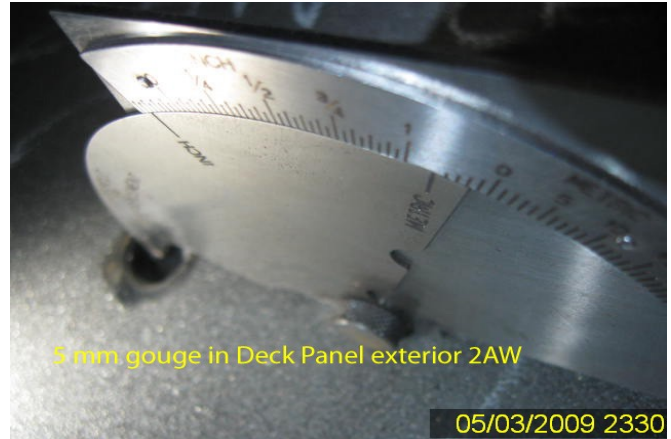
This QA Inspector observed the following work in progress: SAW welding of weld joint 146 and 147 located on

WELDING INSPECTION REPORT

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Tower component NSD1-TL8E-L. ZPMC welder was identified as Jia Quan. ZPMC QC is identified as Liu Liang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
